

Work Order ID 143609

143609

Reprint

Page 1

Item ID: D350-578-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: AS350/AS355 Bearpaws

Start Date: 3/21/2016 Start Qty: 900

4 4 SA
6 4 SA

Cust Item ID:

Required Date: 4/1/2016 Req'd Qty: 900

Customer:

Reference:

Approvals:

Process Plan: SA

Date: 20160412

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-578	H								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-578-011 CHG006								
160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.00							
Quality Control									

DAS
6
9-89

DAS
28
9-89

APR 26 2016

APR 13 2016

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

APR 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Work Order ID 143609***143609***

Page 2

Item ID: D350-578-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AS350/AS355 Bearpaws

Start Date: 3/21/2016 Start Qty: 9.00

~~*Q*~~ 4X

Cust Item ID:

Required Date: 4/1/2016 Req'd Qty: 9.00

~~*Q*~~

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

180

Packaging

Packaging

0.00

BAS
27
9-89

4X

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-578-011 Location: _____

fg 013

APR 26 2016

190

190

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.02

MCS

APR 27 2016

MCS

APR 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

April 13, 2016 11:17:10 AM

Page 1

Work Order ID: 143609

143609

Parent Item: D350-578-011

D350-578-011

Parent Item Name: AS350/AS355 Bearpaws

Start Date: 3/21/2016

Required Date: 4/1/2016

Start Qty: 9.00

Required Qty: 9.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2432 *D2432* Bearpaw 19" X 24"		Manufactured	No			160	Each	8.0000	2	18 8			DAS 6 27 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST430A		8				8			
				142760		8				8			
D2529 *D2529* Washer		Manufactured	No			160	Each	176.0000	12	108 48			DAS 6 27 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST009		176				48			
				141458		176				48			
D3601-1 *D3601-1* Radius Block		Manufactured	No				Each	20.0000		12 108 48			DAS 6 27 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST046		20				48			
				141269		20				48			
D4011-1 *D4011-1* Clamp, Short		Manufactured	No				Each	60.0000	6	18 54 24			DAS 6 27 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST544		60				24			
				141469		60				24			

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Picklist Print

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Page 2

Work Order ID: 143609

143609

Parent Item: D350-578-011

D350-578-011

Parent Item Name: AS350/AS355 Bearpaws

Start Date: 3/21/2016

Required Date: 4/1/2016

Start Qty: 9.00

Required Qty: 9.00

D4012-1

Manufactured No

Each

54.0000

**

D4012-1

Cushion

Location

Loc Qty

Loc Code

FG

5

133458

5

ST545

49

143847

49

Each

274.0000

**

AN4-16A

Purchased

No

AN4-16A

Bolt

Location

Loc Qty

Loc Code

FG

5

121541

5

over003

225

M134509

100

M134606

125

ST343

44

M134502

44

APR 13 2016

Picklist Print

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Page 3

Work Order ID: 143609

143609

Parent Item: D350-578-011

D350-578-011

Parent Item Name: AS350/AS355 Bearpaws

Start Date: 3/21/2016

Required Date: 4/1/2016

Start Qty: 9.00

Required Qty: 9.00

NAS1149D0463J

Purchased

No

160

Each

3,541.000

24

216 96

NAS1149D0463J

WASHER

**DAS
27
9-89**

Location

Loc Qty

Loc Code

GA	136
M129390	41
M132035	95
ST260a	2376
M134508	1000
M134573	1376
ST263	41
M134039	41
ST269	988
M132317	100
M132677	888

**DAS
6
9-89**

**DAS
28
9-89**

MS21042L4

Purchased

No

160

Each

2,516.000

12

108 48

MS21042L4

Locknut

Location

Loc Qty

Loc Code

FP001	37
m133363	37
GA	381
m133769	381
OVER007	1500
m134509	500
m134606	1000
ST303	501
m134055	9
m134502	492
ST305	97
m130922	97

**DAS
27
6 9-89**

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**DAS
28
9-89**

48

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Shop Packet Print

Page 3

Work Order ID 143609

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143609

Reprint

Page 1

Item ID: D350-578-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: AS350/AS355 Bearpaws

Start Date: 3/21/2016 Start Qty: 900

6

4

Cust Item ID:

Required Date: 4/1/2016 Req'd Qty: 900

6

4

Customer:

Reference:

Approvals: Process Plan: *SA* Date: *20160412* Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-578	H								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-578-011 CHG006								
160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.00							
Quality Control									

MLJ APR 14 2016

(4)

4
APR 13 2016

DAS
6
80

DAS
28
9-89

5.0 PARTS LIST

5.1 D350-578-011/-013/-015/-017/-021 BEARPAW INSTALLATION

Qty -011	Qty -013	Qty -015	Qty -017	Qty -021	Qty -031	Part Number	Description
X						D350-578-011	BEARPAW INSTALLATION
	X					D350-578-013	BEARPAW INSTALLATION
		X				D350-578-015	BEARPAW INSTALLATION
			X			D350-578-017	BEARPAW INSTALLATION
				X		D350-578-021	BEARPAW INSTALLATION
					X	D350-578-031	WEARPLATE KIT
2						D2432F	Bearpaw
		2				D2432-3	Bearpaw
12	12	12	12	12		D2529	Washer
				2		D2672F	Bearpaw
12	12	12	12	12		D3601-1	Radius Block (Replaces D2274)
					2	D3859-041	Wearplate
6	6	6	6	6		D4011-1	Clamp (Replaces D2438)
6	6	6	6	6		D4012-1	Cushion (Replaces D2182B050)
	2					D4297-1	Bearpaw
			2			D4297-3	Bearpaw
12	12			12	12	AN4-16A	Bolt
		12	12		12	AN4-17A	Bolt
24	24	24	24	24	24	NAS1149D0463J	Washer
12	12	12	12	12	12	MS21042L4	Nut (or MS21042-4)

5.2 D350-578-111/-113/-115/-117/-121 BEARPAW INSTALLATION

Qty -111	Qty -113	Qty -115	Qty -117	Qty -121	Part Number	Description
X					D350-578-111	BEARPAW INSTALLATION
	X				D350-578-113	BEARPAW INSTALLATION
		X			D350-578-115	BEARPAW INSTALLATION
			X		D350-578-117	BEARPAW INSTALLATION
				X	D350-578-121	BEARPAW INSTALLATION
1					D350-578-011	Bearpaw Installation
	1				D350-578-013	Bearpaw Installation
		1			D350-578-015	Bearpaw Installation
			1		D350-578-017	Bearpaw Installation
				1	D350-578-021	Bearpaw Installation
1	1	1	1	1	D350-578-031	Wearplate Kit